

Work Order ID 57457

April 7, 2010 9:57:57 AM



Page 1

Item ID:	D3204-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Release Pedal Assembly					
Start Date:	07/04/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	16/04/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-4-07	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3204	Rev A1								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. □2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. □3- Use JB weld compound to plug the hole after assembly. □4- Grind JB weld flush after it is cured. □Ident								

EL 10-7-6 (X4)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

x4 BE 10/07/07

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

Siobhán

(X4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00				H	BR	10-7-7	
Hand Finishing									
140 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	***Cover holes for bushing*** START TIME: 10:45 OVEN TEMPERATURE: 320° FINISH TIME: 11:15					H	BR	10-7-7	
150 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				4	φ		
Quality Control									

U 10/07/07

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Install D3204-7 bushing as shown in Dwg D3204								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	Identify as per dwg & Stock Location: <u>197</u>	0.00							
Packaging	Memo	0.00							
Packaging									

Ep 5/07/08 (4)

8/01/07/08

(4)

6/19/7/8 (4)

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Setup Start



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Run Start



QC:

Date:

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Date:

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10709
MF
10-7-8

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Picklist Print

April 7, 2010 9:58:02 AM

Page 1 / 3

Work Order ID: 57457

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Comments: IPP: ☐ C ☐ 05.08.11 ☐ Added Step 25 ☐ KJ/JLM ☐


Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3204-1  Tube		Manufactured	No			100	Each	5.0000	4.0000			
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57547 x3

Warehouse

Loc Qty


Loc Code

Location

Main Warehouse

WA

55464

D3204-11  Plate		Manufactured	No			100	Each	5.0000	4.0000			
--	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Warehouse

Loc Qty


Loc Code

Location

Main Warehouse

WA

55463

D3204-3  Arm		Manufactured	No			100	Each	7.0000	4.0000			
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Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

47570

B57737 x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2 13

Work Order ID: 57457

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Comments: IPP: ☐C05.08.11 ☐Added Step 25 ☐ KJ/JLM

Start Date: 07/04/2010

Required Date: 16/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3204-5		Manufactured	No			100	Each	6.0000	4.0000			
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Arm

EL 10-7-6

B 57738 x2

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

6

43763

6

D3204-7		Manufactured	No			100	Each	29.0000	8.0000			
---------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Bushing

2
P2147/7

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST045

29

46971

5

48631

24

D3204-9		Manufactured	No			100	Each	13.0000	4.0000			
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Pedal

48631

EL 10-7-6

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

13

43765

5

56311

8

4

April 7, 2010 9:58:02 AM

Shop Packet Print

Page 2

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Work Order ID: 57457



Parent Item: D3204-041



Parent Item Name: Release Pedal Assembly



Start Date: 07/04/2010

Required Date: 16/04/2010

Comments: IPP: ☐ C ☐ 05.08.11 ☐ Added Step 25 ☐ KJ/JLM ☐

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3204-13  Gusset		Manufactured	No			160	Each	17.0000	8.0000 		<i>EZ 10-8-6</i>	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

17

55365

17

8

April 7, 2010 9:58:02 AM

Shop Packet Print

Page 3

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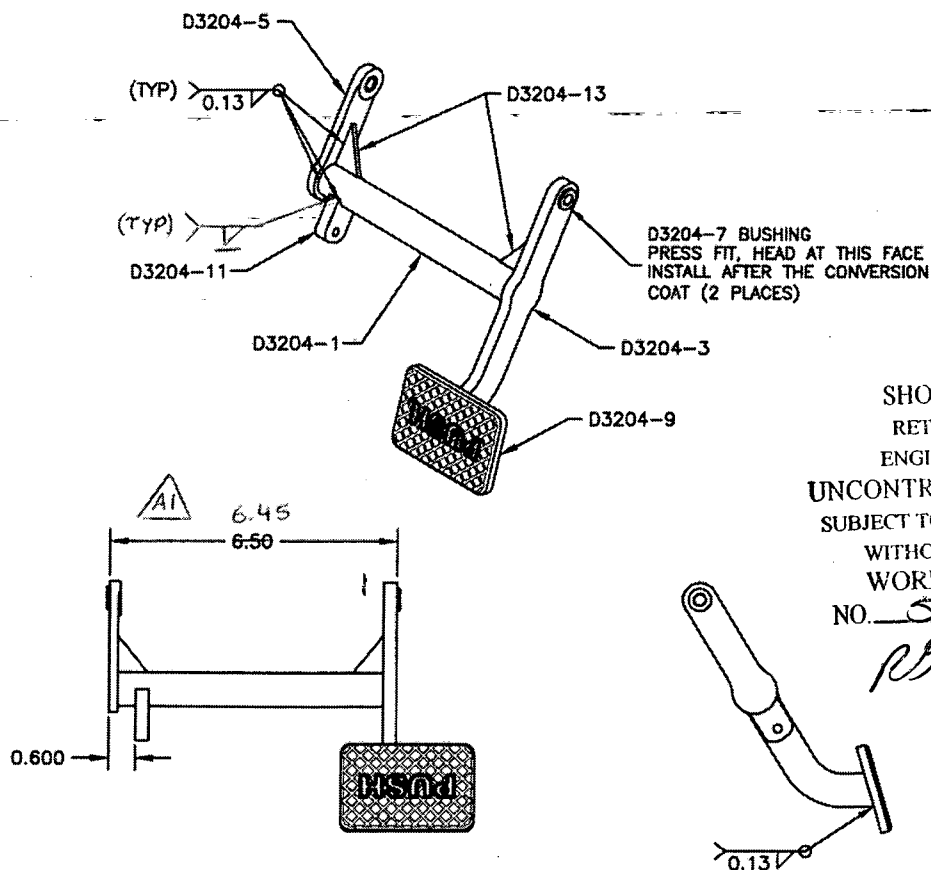
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57457
RD 10-4-07

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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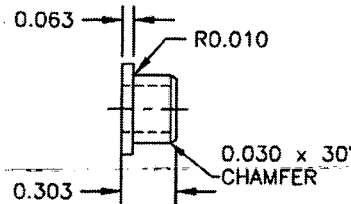
NOTE: Date & initial all entries

DART

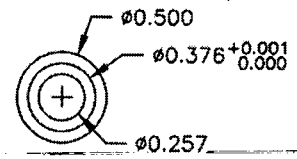
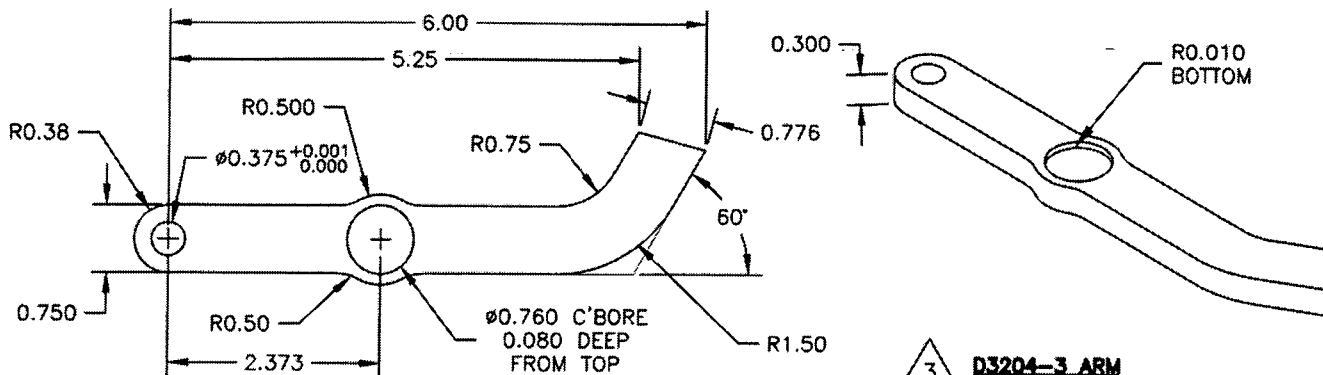
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.05

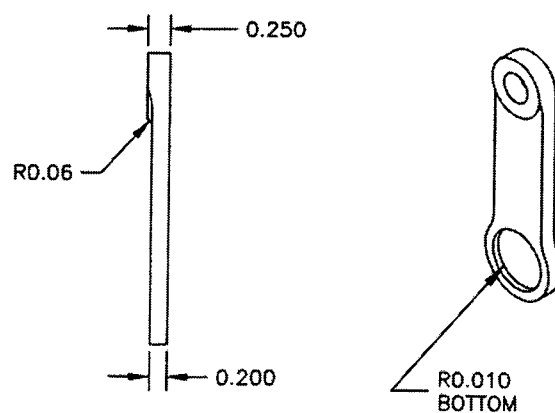
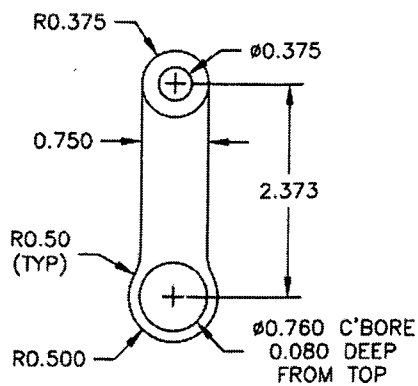
2 **D3204-1 TUBE**
SCALE 1:2



4 **D3204-7 BUSHING**
SCALE 1:1

*w/d 57457*

3 **D3204-3 ARM**
SCALE 1:2



3 **D3204-5 ARM**
SCALE 1:2

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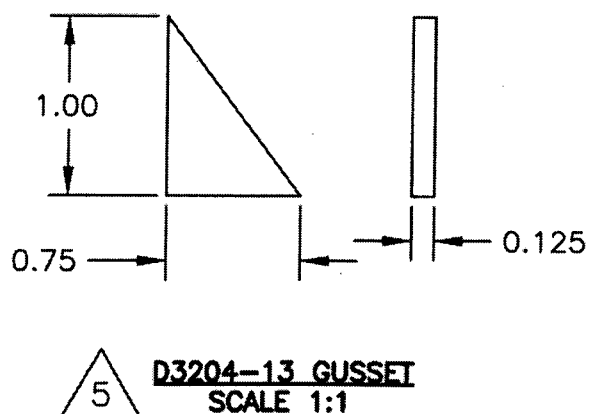
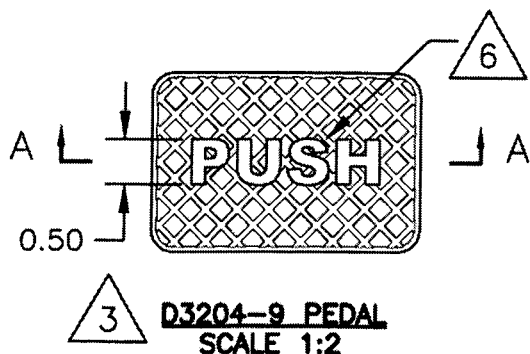
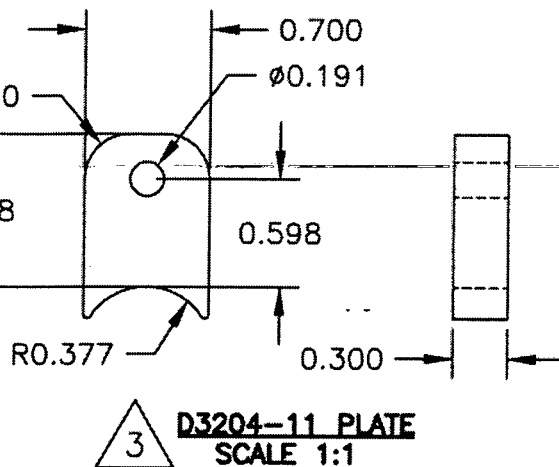
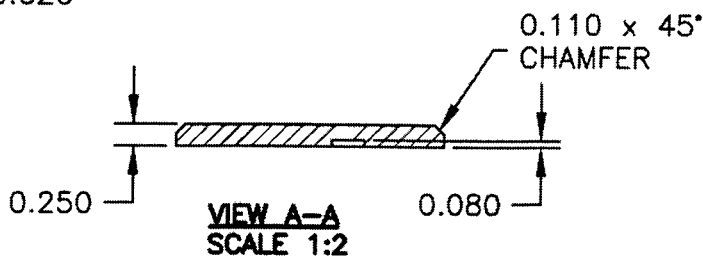
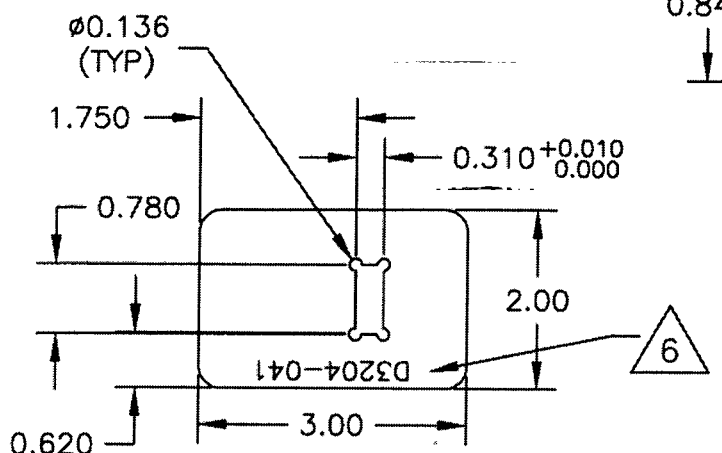
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04.04.30



W1057457

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